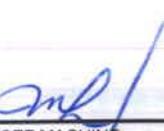
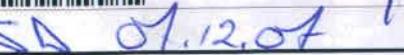


Date: Friday, 30/11/2007 1:01:37 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 36085	Part Number	: D3610041
Estimate Number	: 12812	Drawing Number	: D3610 REV.A
P.O. Number	:	Project Number	: N/A
This Issue	: 30/11/2007	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 07/12/2007
Previous Run	: 32832	Qty:	20
Written By	: <u>W</u>	Um:	Each
Checked & Approved By	: <u>W</u>		<u>Wad 2007</u>
Comment	: est rev A new issue 07.03.28 EC est rev B released, changed mat'l EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M4140NB1500X15000	AISI 4140 Steel Bar 	
Comment: Qty.: 0.5775 f(s)/Unit Total : 11.5500 f(s) AISI 4140 Steel Bar			
2.0	BAND SAW	BAND SAW NO MATEL. in computer. 	
Comment: BAND SAW Batch M106451 X20 Cut blank 6.600 " long  M104993 X2 On 07/12/05 (26)			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 	
Comment: HAAS CNC VERTICAL MACHINING #1			
1- Mill as per Folio FA692 Rev: <u>A</u> & Dwg D3610 Rev: <u>A</u>  J.L 07/12/07			
2-Deburr per dwg D3610			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE  J.L 07/12/07			
5.0	QC8	SECOND CHECK 	
Comment: SECOND CHECK  SD 07.12.07 F			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/11/2007 1:01:37 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET
Job Number: 36085		Part Number: D3610041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-C'SINK AS PER DWG D3610		mf 07-12-07 (17)
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		6 7/12/07 (17) counts
8.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	M105642	17X
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		mf 07-12-07
10.0	MS21075L3	Nutplate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Nutplate Batch: M18057	-2 in computer	AS 07/12/07 X17
11.0	MS20426AD34	RIVET
Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) RIVET batch: M102404		AS 07/12/07 X17
12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Rivet Nut Plate as per Dwg D3610	mf	07-12-07 (17)
13.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		5 7/12/07 (17) counts

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/21/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/11/2007 1:01:37 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 36085

Part Number: D3610041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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14.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST247A

6/12/07 (17)

15.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

(17) 07/12/07

Job Completion



6/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

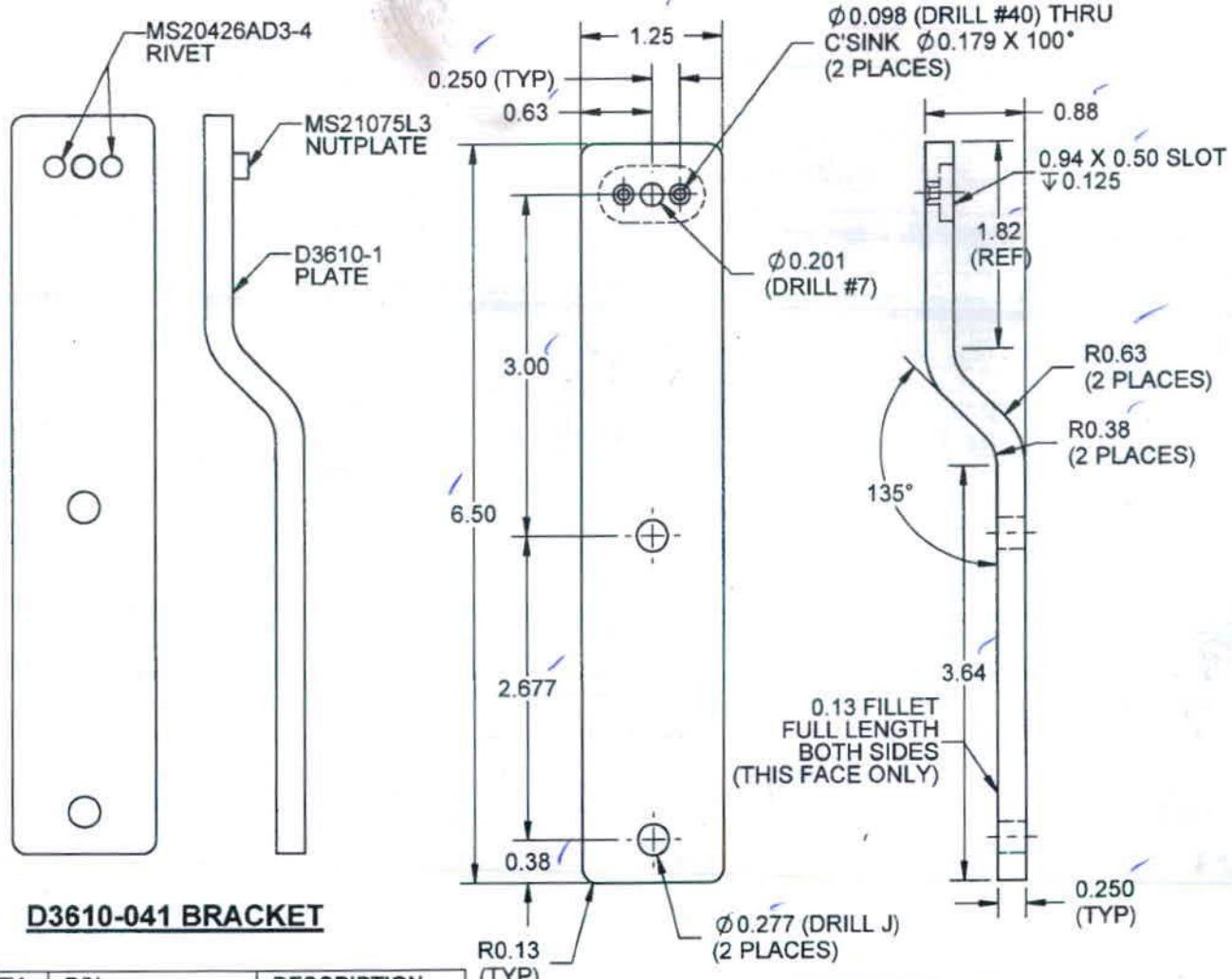
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3610
DATE 07.04.20		REV. A SHEET 1 OF 1
		TITLE BRACKET SCALE 2:3

REV	DATE	DESCRIPTION
A	07.04.20	NEW ISSUE



QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

RELEASED

07.04.25

D3610-041 NOTES:

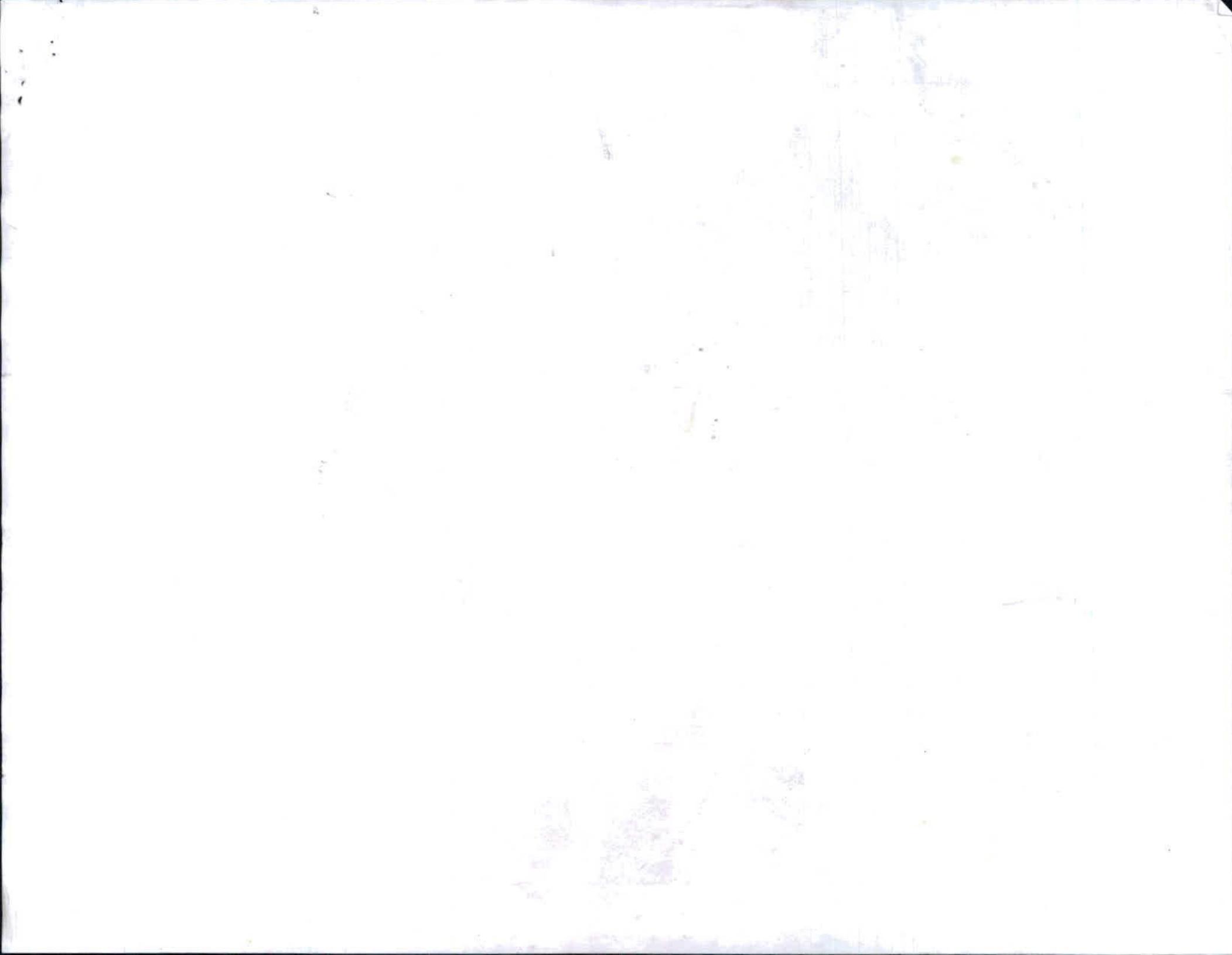
- 1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD	Work Order:	36085
Description: bracket	Part Number:	D361004
Inspection Dwg: A3610 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.125	$\pm .030$.1247	✓			
.250	$\pm .010$.250	✓			
.098	$\pm .005$ $-.001$.100	✓			
.63	$\pm .030$.624	✓			
.201	$\pm .005$ $-.001$.204	✓			
.50	$\pm .030$.498	✓			
3.00	"	2.998	✓			
2.677	$\pm .010$	2.677	✓			
.38	$\pm .030$.373	✓			
.130	$\pm .030$.130	✓			
.277	$\pm .005$ $-.001$.279	✓			
.88	$\pm .030$.879	✓			
.94X.50	$\pm .030$.940X.501	✓			
.82	"	.827	✓			
3.64	$\pm .030$	3.648	✓			
.250	$\pm .010$.250	✓			
1350	$\pm 1^{\circ}$	1350°	✓			
J.05	$\pm .010$					

Measured by:	J.L.
Date:	07/12/06

Audited by: J.F
Date: 07/12/06

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

